

# Work Order ID 61844

Tuesday, September 07, 2010 3:37:40 PM



Page 1

Item ID:	D2743	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Crossbolt Spacer					
Start Date:	9/7/2010	Start Qty:	100.00		Cust Item ID:	
Required Date:	9/13/2010	Req'd Qty:	100.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>M</u>	Date:	<u>10-9-08</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2743	Rev B								

100		Hardinge CNC LATHE SMALL	0.00						
Hardinge		Memo	0.00						
Hardinge CNC Lathe Small		1-TURN AS PER FOLIO FA202 & DWG D2743							
		FOLIO REV: <u>A</u>		<u>SA</u>	<u>10/02/25</u>				
		DWG REV: <u>A</u>							
		2-DEBURR AS REQUIRED							
110		QC2- Inspect parts off machine FAI/FAIB	0.00						
QC		Memo	0.00						
Quality Control				<u>SA</u>	<u>10/09/25</u>				

107 6

107 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 61844**

Tuesday, September 07, 2010 3:37:40 PM



Page 2

Item ID: D2743

Accept



Setup Start



Revision ID:

Stop



Item Name: Crossbolt Spacer

Start Date: 9/7/2010 Start Qty: 100.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

J.A

10/09/27

107

Ø

Memo

0.00

130



Skidtubes

Skidtubes

Memo

1- Clean crossbolt spacer with ultra bright aluminum cleaner

0.00

0.00

107

Ø

BE 10/09/30

160



Packaging

Packaging

Identify as per dwg &amp; Stock Location

LG

0.00

Memo

\*\*\*STOCK IN SKIDTUBE CELL\*\*\*

0.00

107

Ø

BE 10/09/30

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Page 3

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Setup Start

Revision ID:

Stop

Item Name: Crossbolt Spacer

Start Date: 9/7/2010 Start Qty: 100.00

Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 100.00

Customer:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/01 *[Signature]*  
MF  
10-10-01

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# Picklist Print

Tuesday, September 07, 2010 3:37:47 PM

Page 1

Work Order ID: 61844



Parent Item: D2743

Parent Item Name: Crossbolt Spacer

Start Date: 9/7/2010

Required Date: 9/13/2010

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP ☐ E ☐ 05.04.13 ☐ Reformat; removed tumble and deburr step ☐ KJ/JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T0.625W.065

Purchased

No

100

f

57.5410

0.2667

28.07368



6061-T6 RD Tube .625 x.065W

Location

Loc Qty

Loc Code

MAT

8

114585

8

MAT014

49.541

110778

1.541

- 114812

48

8 ~~ERT~~

22 ~~ERT~~ 1.541 ~~RT~~ SH 100V25

\* Could not pull material

W/O:		WORK ORDER CHANGES					
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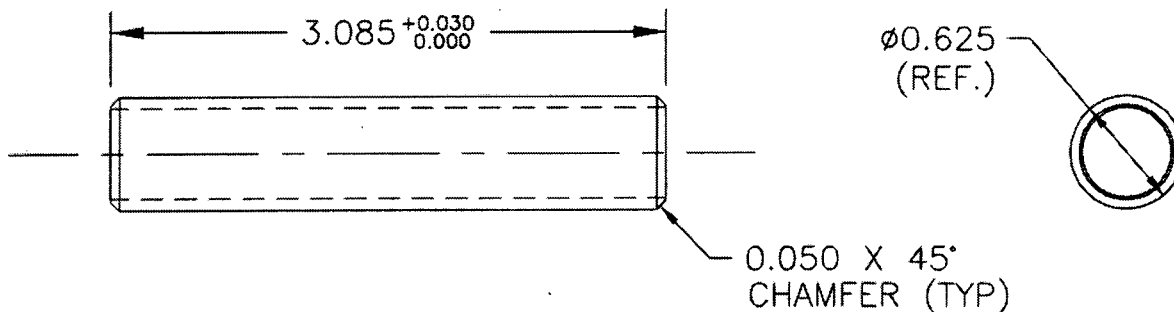


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>KE</i>	DRAWING NO. D2743	REV. B SHEET 1 OF 1
DATE 98.12.08		TITLE CROSS BOLT SPACER	SCALE 1:1
A	98.04.16	NEW ISSUE	
B	98.12.08	3.085 WAS 3.060	

RELEASED  
98.2.16 DS

SHOW COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO ANALYSIS  
WITHOUT NOTICE  
WORK ORDER  
NO. *66844*

*810-9-08*



MATERIAL: 6061-T6 (WW-T-700/6) 0.625 DIA. X 0.065 WALL  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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